

Date: Monday, 02/02/2009 11:50:19 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 45398	
Estimate Number : 10428	
P.O. Number :	Part Number : D32351
This Issue : 02/02/2009 S.O. No. :	Drawing Number : D3235 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 45269	Material :
Written By :	Due Date : 15/02/2009 Qty: ¹⁰⁰ / ₅₀ Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
Comment: Qty.: 0.0717 f(s)/Unit Total : 3.5858 f(s) Lug Extrusion D2423 extrusion Batch: <u>B 43722</u>		
2.0	BAND SAW	BAND SAW
Comment: Band Saw Cut D2423 extrusion to 0.820" Batch: <u> </u>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA369 and Dwg D3235 2-Identify as D3235-1 3-Deburr <u>210.8130</u> <u>CL 02/02/09</u> <u>(100)</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>recd + inspect for transit damage - attached c/c</u> <u>6/9/27</u> <u>(100)</u>		
5.0	QC2	SECOND CHECK
Comment: SECOND CHECK <u>50100/07</u> <u>(100)</u> <u>counter</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



X109

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

mp/FL

09/03/02

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S or 03/02 X109

8.0

POWDER COATING

POWDER COATING



X101

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME:

11:55

OVEN TEMPERATURE:

320[°]

FINISH TIME:

12:25

FL 09/03/02

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



X102

Comment: INSPECT POWDER COAT

BR 04-03-2

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

B ST 471

SS 09/03/03 X101

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

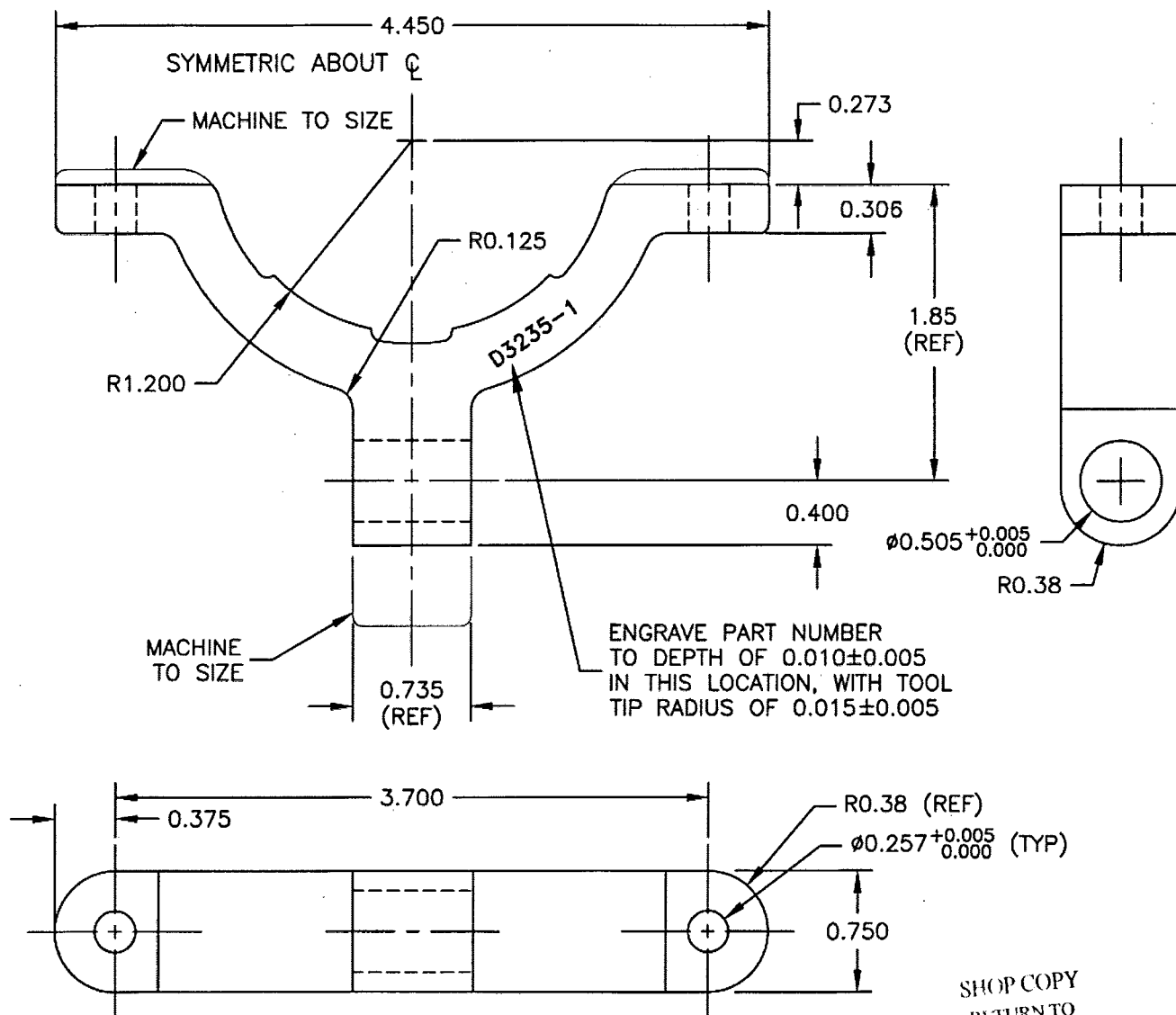
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
NO. 45398

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
101	D3235-1	Mounting Lug	8130

MATERIAL: supplied by DART D2423 B43722

Signature
02/26/09

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Signature
Shigi Walz

Vankleek Hill, February 26, 2009